

Date: Monday, 6/5/2006 7:47:55 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER		
Job Number	: 27377		Part Number	: D314091		
Estimate Number	: 11465		Drawing Number	: D3140 REV D1		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 6/5/2006 S.O. No. : N/A		Drawing Revision	: D1		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 6/30/2006		
Previous Run	: 25730		Qty:	4	Um:	Each
Written By	: <i>See Comment Below</i>					
Checked & Approved By	: <i>Off 06.06.05</i>					
Comment	: Est. A0204.30 New Issue NG Est. Rev B New dwg rev. ecn781 06.04.18 EC.					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S032	2024-T3 .032 sheet 
<p>Comment: Qty.: 0.1549 sf(s)/Unit Total : 0.6195 sf(s)            2024-T3 .032 sheet            Matl: 2024-T3 ( QQ-A-250/4 ) .032" thick            ( M2024T3S.032 ) 5.00" x 4.06" flat pattern ref            Note grain direction Batch <i>M100284</i> <i>MM 06 06 08</i></p>		
2.0	SHEAR 	SHEAR 
<p>Comment: SHEAR            Cut as per dwg D3140</p>		
3.0	HAAS1 	HAAS CNC VERTICAL MACHINING #1 
<p>Comment: HAAS CNC VERTICAL MACHINING #1            Deburr. No sharp edges            Notch out .75 x .40 corner as per dwg (-91 shown)            Form as per dwg (-91 shown)  <i>Waterjet</i>  <i>Day Rev. D1</i>  <i>Nig Rev D1</i> <i>MM 06 06 08 D1</i></p>		
4.0	<i>QC2</i> 	INSPECT WORK TO CURRENT STEP 
<p>Comment: INSPECT WORK TO CURRENT STEP <i>MM 06 06 08 (4)</i></p>		
5.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1 
<p>Comment: HAND FINISHING RESOURCE #1            Chemical Conversion Coat as per QSI 005 4.1  <i>a.m</i> <i>06-06-13</i>  <i>4.1 QC8</i> <i>J 06-06-12 (4)</i> <i>D10 (4)</i></p>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes  No  DQA: Date: 06/06/14

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

Date: Monday, 6/5/2006 7:47:56 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 27377

Part Number: D314091

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

C206113106 (4)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:       

C206113106 (4)

8.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DS 06/06/14 (4)

U 06-06-14

Job Completion



4.2 Small fab. form.

8B 06/06/13 (4)

4.3 QCS

206-06-13 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**

DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3140	REV. D SHEET 1 OF 7
DATE 05.11.23		TITLE DOOR	SCALE NTS
		A 02.04.18 NEW ISSUE	
		B 03.01.23 REMOVE -65/-81/-83; ADD -301/-303	
		C 04.11.08 CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106'	
		D 05.11.23 ADD -103/-104/-105/-106; REMOVE -67	
		D1 <i>[initials]</i> 06.03.31 1.75 WAS 1.88; 4.75 WAS 4.13	

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
				1	X	D3140-09	DOUBLER ASSEMBLY
					1	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
			1			D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
	1					D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
			1			D3140-105	DOUBLER
			1			D3140-106	DOUBLER
				1		D3140-241	DOUBLER
1	1					D3140-301	DOUBLER
1		1				D3140-303	DOUBLER
	1		1				UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE
				5	5	MS20426AD3-4	RIVET
							WORK ORDER NO. <i>2731</i>

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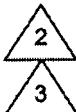
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**DART**

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3140	REV. D SHEET 2 OF 7
DATE 05.11.23		TITLE DOOR	SCALE NTS



1 COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77  
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006  
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.  
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM



2 FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3 MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

RELEASED  
05-12-01-4



4 MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



5 MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



6 MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



7 MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECCELL



8 ALL DIMENSIONS IN INCHES



9 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



10 MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



11 DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION



12 DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION



13 RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

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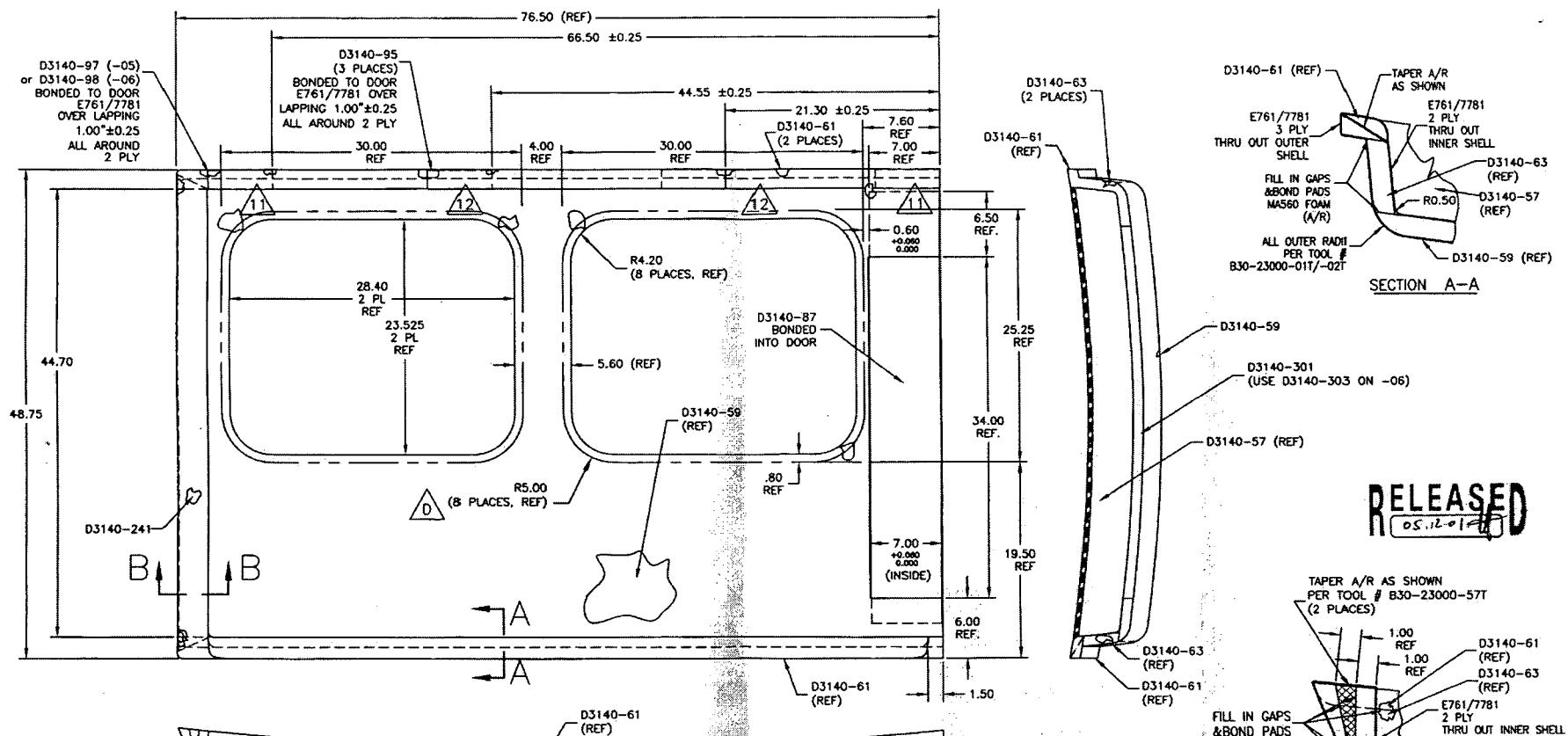
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D3140-05 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-05)  
D3140-06 DOOR (OPPOSITE, REPLACES PREMIER P/N B30-23000-06)  
(WINDOWS & CUTOUTS TO BE LOCATED PER B30-23000-017 - 027 TOOL)

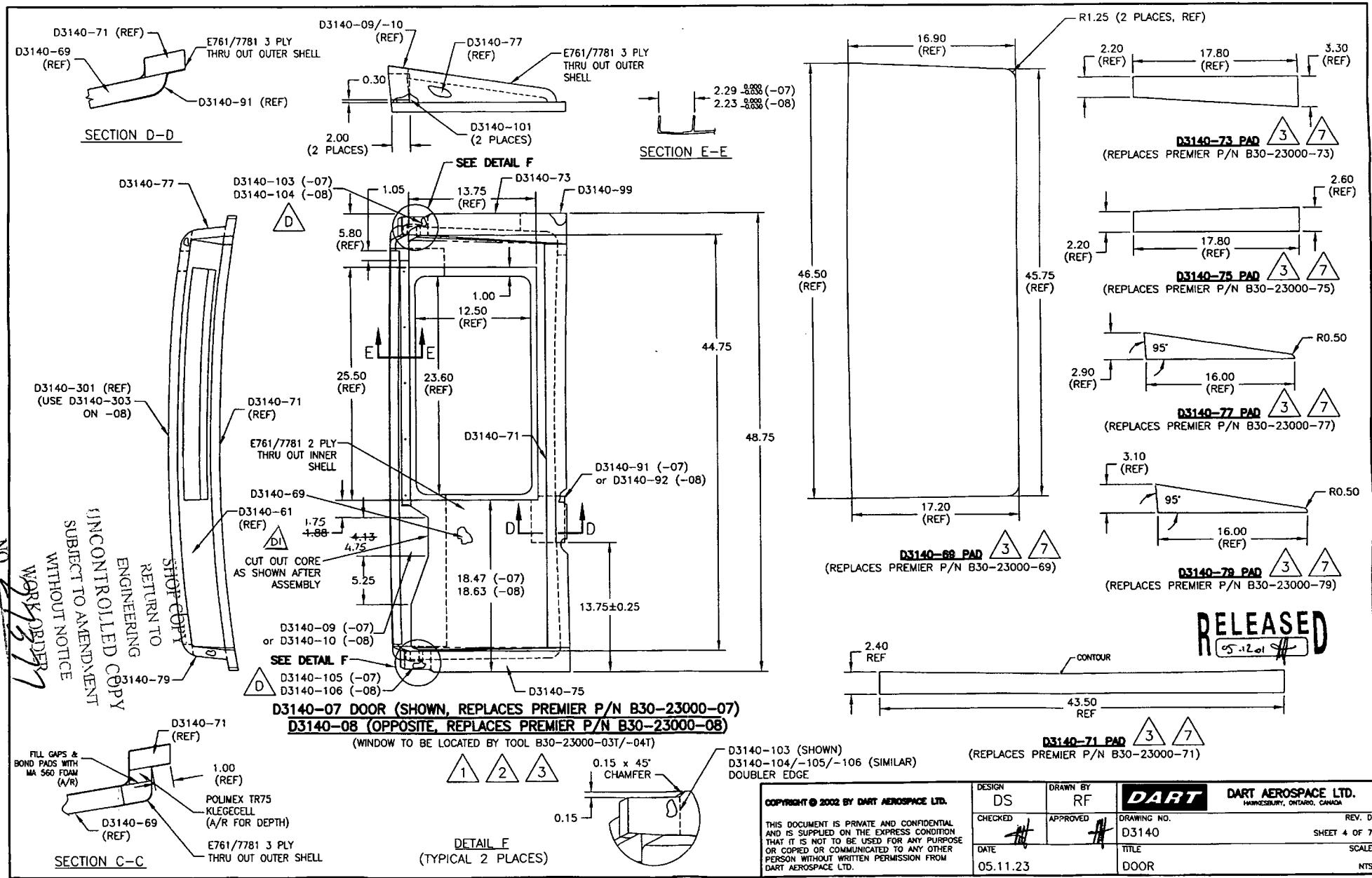
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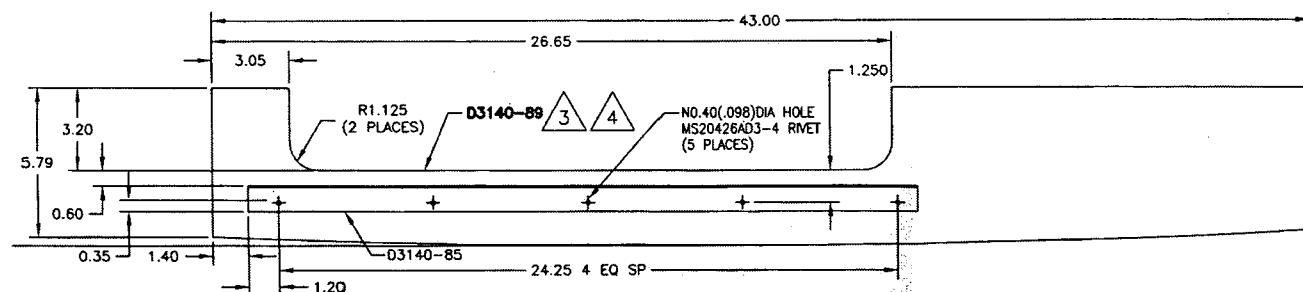
卷之三十一 2020年10月 2020年10月

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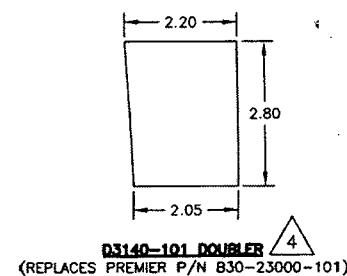
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3140	REV. 0 SHEET 3 OF 7
DATE 05.11.23	TITLE DOOR		SCALE NTP

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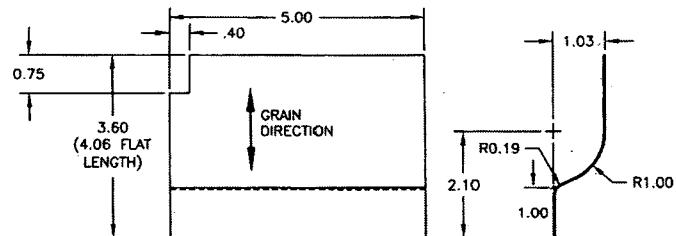




**D3140-10 DOUBLER ASSEMBLY (SHOWN, REPLACES PREMIER P/N B30-23000-10)**  
**D3140-09 DOUBLER ASSEMBLY (OPPOSITE, REPLACES PREMIER P/N B30-23000-09)**

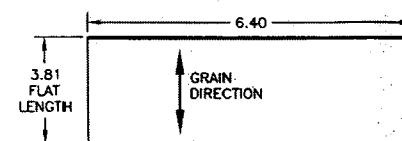
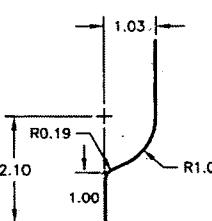


**D3140-101 DOUBLER** 4  
 (REPLACES PREMIER P/N B30-23000-101)



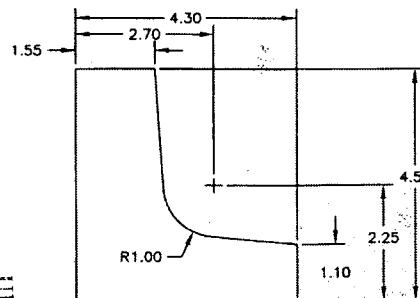
**D3140-91F FLAT PATTERN**  
 (USE TO MAKE D3140-91/-92 DOUBLERS)

**D3140-91 DOUBLER** 4  
 (SHOWN, REPLACES PREMIER P/N B30-23000-91)  
**D3140-92 DOUBLER**  
 (OPPOSITE, REPLACES PREMIER P/N B30-23000-92)

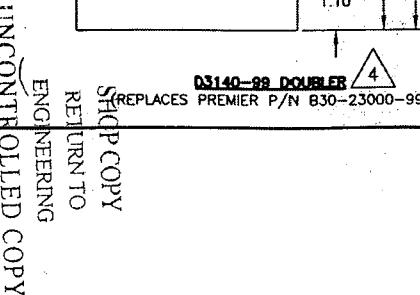


**D3140-95 DOUBLER** 4  
 (REPLACES PREMIER P/N B30-23000-95)

RELEASED  
 05/12/01

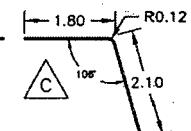


**D3140-98 DOUBLER** 4  
 (REPLACES PREMIER P/N B30-23000-99)



**D3140-97F FLAT PATTERN**  
 (USE TO MAKE D3140-97/-98 DOUBLERS)

**D3140-97 DOUBLER** 4  
 (SHOWN, REPLACES PREMIER P/N B30-23000-97)  
**D3140-98 DOUBLER**  
 (OPPOSITE, REPLACES PREMIER P/N B30-23000-98)



BEND DETAIL

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DESIGN  
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CHECKED

APPROVED

DATE

05.11.23

DRAWN BY  
 RF

DRAWING NO.

D3140

TITLE

DOOR

**DART**

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 HAMPSHIRE, ENGLAND, CANADA

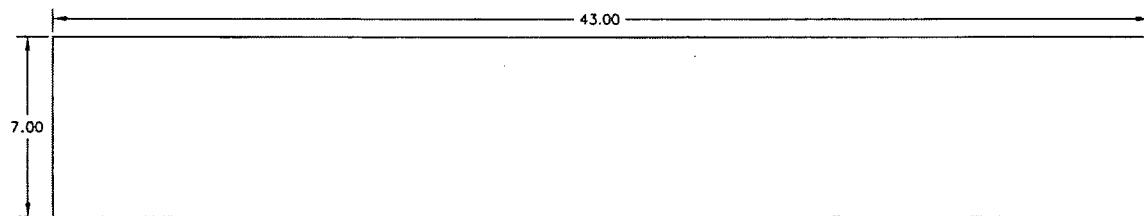
REV. 0

SHEET 5 OF 7

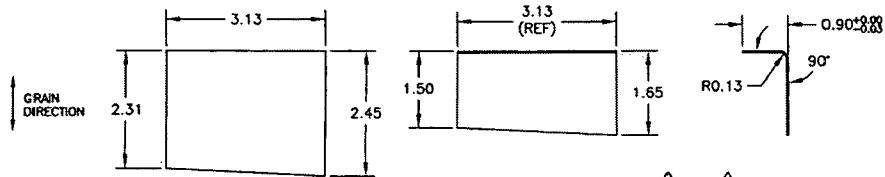
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 NO. 27327

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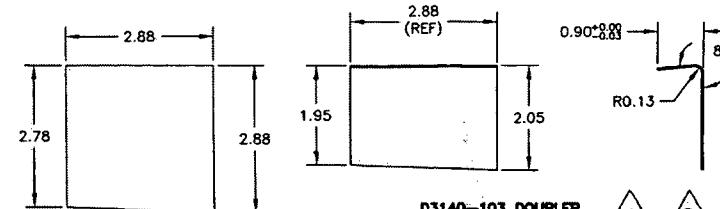


**D3140-87 DOUBLER** 4  
(REPLACES PREMIER P/N B30-23000-87)



**D3140-105F FLAT PATTERN**  
(USED TO MAKE D3140-105/-106 BRACKETS)

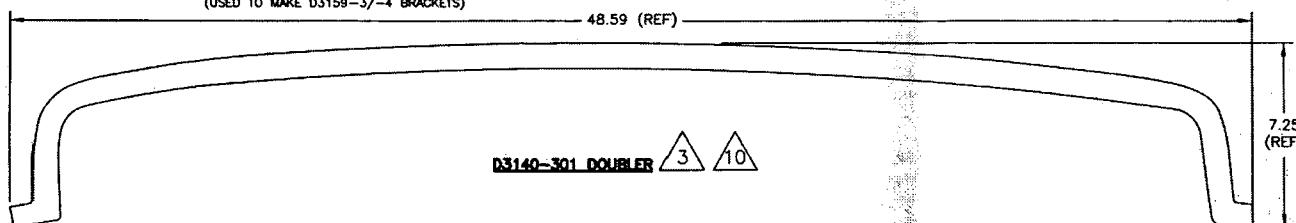
**D3140-105 DOUBLER** 4  
**D3140-106 OPPOSITE** D



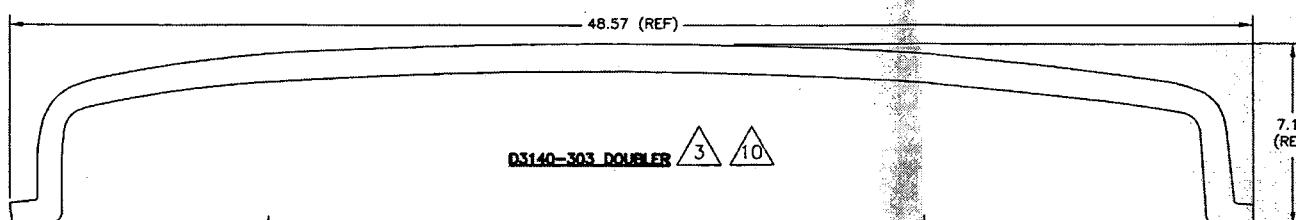
**D3140-103F FLAT PATTERN**  
(USED TO MAKE D3140-103/-104 BRACKETS)

**D3140-103 DOUBLER** 4  
**D3140-104 OPPOSITE** D

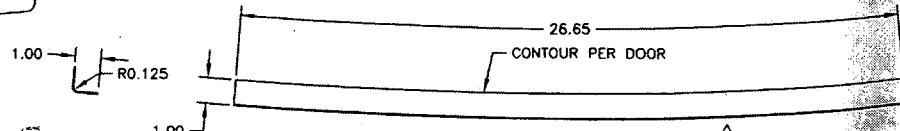
**D3159-3F FLAT PATTERN**  
(USED TO MAKE D3159-3/-4 BRACKETS)



**RELEASED**  
05.12.01



**D3140-303 DOUBLER** 3 10



**D3140-85 ANGLE** 6  
FLAT PATTERN: 26.65" x 1.90"  
(REPLACES PREMIER P/N B30-23000-85)

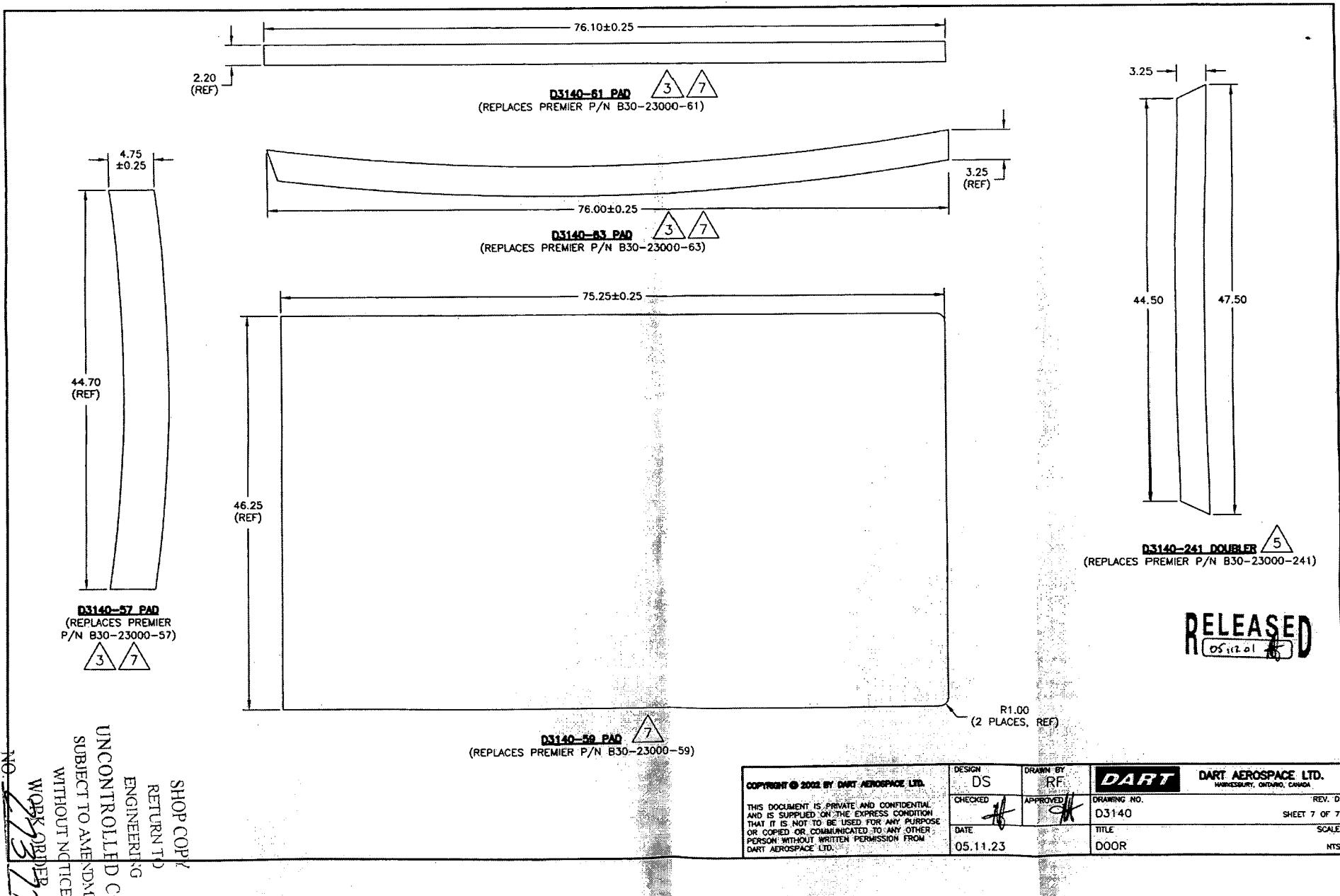
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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
DS	RF		REV. D
CHECKED	APPROVED	D3140	SHEET 6 OF 7
DATE		TITLE DOOR	SCALE NTS
05/11/23			

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DART AEROSPACE LTD	Work Order:	27377
Description:	Part Number:	3140-91
Inspection Dwg:	Rev:	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article X Prototype

Measured by:		Audited by:		Prototype Approval:	
Date:	06.06.08	Date:	 06.06.12	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	